Work Orde September-11-1.				*106	3786*							Page 1
Item ID: Revision ID: Item Name:	D4008-11 Hinge Half			Accept	*N900	040	100)*	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	9/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:							. 12
Approvals:	Process Plan	n:	Date:/3-1946	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										·
D4008	С											_
100				0.00								11
100 Small Fab		Memo		0.00				6X				G/13/
Small Fab		1- Cut Hing	ge as per Dwg keep 2nd half t	for D4008-5								
		2- Deburr										
*110		QC5- Inspect part comp	eleteness to step on W/O	0.00								
QC Quality Control		Memo		0.00					<u> </u>			
120		Identify as per dwg & Si	tock Location: WAOOA	0.00				A .	Ş A	<u>,</u>		
120 Packaging		Memo		0.00	•			6X	- 	5 •	13-	09-18

Packaging

										DQA	: Date	!:
NCR: Y	es / N	o			WORK ORDER NON-O	COI	NFORM	/ANCE / UP	DATE			-
										QA Closed	i: Date):
Work Orde	sė.				DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS	
WOIK OIGE					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	Quality
					Use-as-is		Therm	noforming	Finishing	Rec/St	ore/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	T	Initial	Ac	ction	Sign &		
Cause	Dat	Date Step Qty or Non-conformance Chief Eng Description						cription	Date	Verification	QC Inspector	
Doc/Data				ļ								
Equip/Tooling						İ						
Operator												
Material												
Setup												
Other					·						1	
Process												
Supplier												
Training												
Unapproved			<u> </u>							<u> </u>		
					F	AUL	T CATE	GORY				
Landi	ng Gear				General		,		_	a	F	¬
	Bendi	ng		ļ	Bend		Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	entric to	O/S	BOM/Route		Hardwa	re .		Over/Unde	er tolerance	Temperature/Cure
	Cracks Broken/Da						4 '	on Incomplete	_	Part Incorr	⊢	Weld
	Crushed/Crimped Burrs					Ŀ	Instruct	ions Incomplete	/Unclear	Part Lost/N	/lissing	Wrong Stock Pulled
	Cuffs			ļ.	Contamination	\perp	Mainte	nance		Part Move	d	
	Heat 1	reat			Countersink		Mislabe	led		Positioned	Wrong	_
	Inspec	tion Strip i	n Tube		Cut Too Short		Misread	I		Power Loss	s/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Ripples in Bend (C)
Torque Waves in Extrusion
Turning Sequence

Drill Holes

Drawing

Finish

Work Ord September-11-				*106	3786*						Page 2
Item ID: Revision ID: Item Name:	D4008-11 Hinge Half			Accept	*N900	040	100) * ፡	Setup Sta		NS1* NS2*
Start Date: 9/11/13 Start Qty: 6.00 Required Date: 9/11/13 Req'd Qty: 6.00			*6* *6*		Cust Item I	D:					
Reference: Approvals: Process Plan: QC:			Date:	Tooling: SPC (Y/N):	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	nte:		Ŧ	Run Sta Ste	on	NR1* NR2*
Sequence ID/ Work Center I	ID	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Numl	_ _

0.00

Memo

Quality Control

MC 13-09-18

										DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.			• • • • • •		Rework Scrap]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Ti	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data					······································				·			
quip/Tooling] .											
Operator												
Material												
etup												•
Other			1									

Landing Gear General Bend Ovalized Pressure/Forced Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Cracks Weld Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Process
Supplier
Training
Unapproved

September-11-13 11:41:57 AM

Work Order ID:

106786

Parent Item:

D4008-11

Parent Item Name:

Hinge Half

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-04-06 JLM VERIFIED BY:EC

ECN10-562 DD verified by:EC

LM VERIFIED BY:EC IPP Rev:B 10.05.03 as per IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC

	LCN10-302 DD V	ciffica by.LC	III KL	V.C 12.03.07	ASILKUN	VOILLY.C DE	V LIG .LC	, 					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	51.5921	0.4	2.526315	6	/3/	28/17
				Location		Loc Oty	<u>Lo</u>	c Code				/	
				ST209a		51.5921048							
				12396	50	6.4552628			<u>ع.</u>	5263	156		
				m1263	275	45.136842					•		

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-O	COI	NFORM	MANCE / UPDA	ATE	•		
										QA Closed:	Date	•
Work Orde	ŕ•				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE	'·				Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	ο.				Scrap	1	B.	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, 5.,					Use-as-is	1	1	noforming	Finishing	4	e/Packaging	Other
NCR N	0				Work Order Update	1		~ —	Composite]	Supplier	
Root				Descr	iption of work order update		Initial	Actio	n	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved						1						
	<u></u>				 	AUI	LT CATE	GORY				
Landin	ng Gear			_	General	_	7			1	_	-
	Bendin			<u> </u>	Bend	_	Grain		ļ	Ovalized		Pressure/Forced
	Centre	Not Conce	entric to (D/S	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		Temperature/Curè
Cracks					Broken/Damaged	\vdash	-i '	on Incomplete		Part Incorred	├	Weld
		d/Crimped	l	·	Burrs	L	4	ions Incomplete/Und	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination		Mainte		_	Part Moved		
1	Heat Tr	eat		1	Countersink	1	Mislabe	eled	1	Positioned V	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish Folio Power Loss/Surge

Other

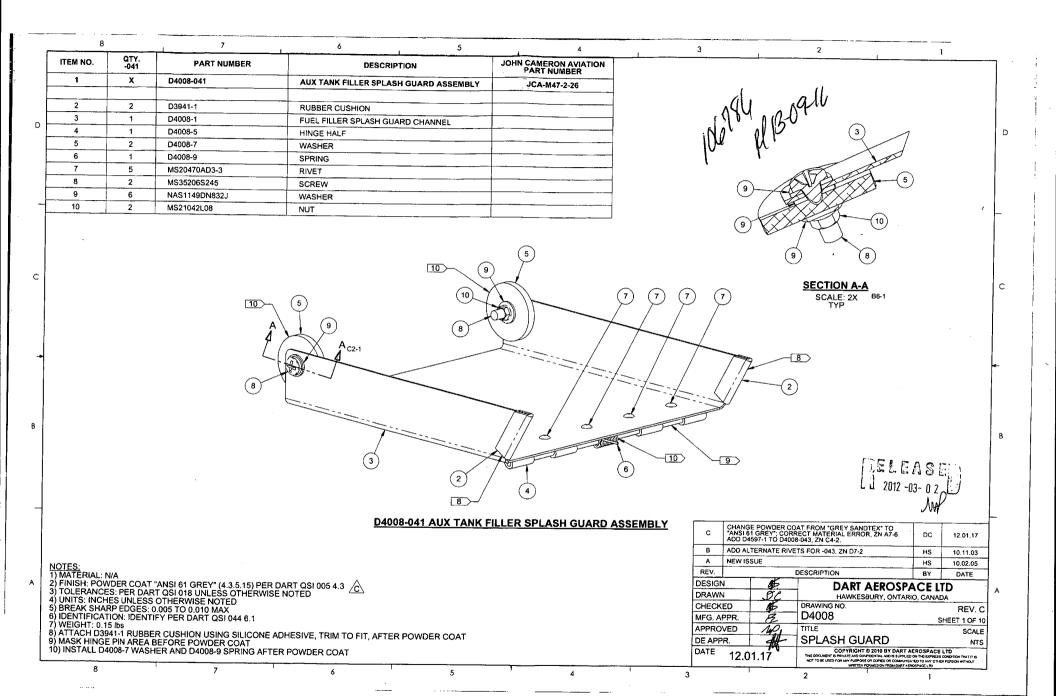
Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion



												DQA:		ate:	
NCR: Y	'es /	No				WORK ORDER NON-C	O	NFORM	MANCE / UPD	ATE	,	QA Closed:	D.	ate:	
								<u> </u>					•	ate.	
Work Orde	er:					DISPOSITION				AGAINST DI	EP.	ARTMENT/	/PROCESS		
Part N	 lo					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor e/Packaging Supplie		Engineering Quality Other
Root	Т				Descri	tion of work order update		I Initial	Actio	on	Τ	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Descri	ption		Date	Verification	on	QC Inspector
Doc/Data														•	
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process											ł				
Supplier							ĺ					:			
Training															
Unapproved															
							AUL	LT CATE	SORY						
Landii					_	General	_	٦.		_	i			_	1 .
	Bend Bend						<u> </u>	Grain			-	Ovalized		\vdash	Pressure/Forced
						BOM/Route	Ŀ	Hardwa		<u> </u>	-	Over/Under			Temperature/Cure
	—	acks			<u> </u>	Broken/Damaged		-	on Incomplete	<u> </u>	-	Part Incorrec		_	Weld
	_		Crimped		ļ	Burrs	<u></u>	4	ons Incomplete/Ur	nclear	┥.	Part Lost/Mis	ssing		Wrong Stock Pulled
	Cuffs Contamination						<u> </u>	Mainte		_	-	Part Moved			
	$oldsymbol{oldsymbol{ ext{-}}}$	eat Trea				Countersink	\perp	Mislabe			-	Positioned W	_	_	1
	lin	spection	n Strip in	Tube		Cut Too Short		Misread			_JF	Power Loss/S	Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

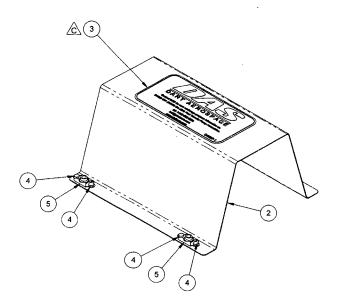
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

				, 6 , 5	. 4	
	ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER	
	1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29	
	2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER		
_ [3	1	D4597-1	PLACARD		6
P	4	8	MS20472M3-3	RIVET		۷.
	5	4	MS21060L3	ANCHOR NUT		



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. C D4008 MFG. APPR. SHEET 2 OF 10 APPROVED TITLE SCALE SPLASH GUARD DE APPR. NTS COPYRIGHT & 2019 BY DART AEROSPACE LTD

THIS DOCUMENT IS REPORT WE DOWNSHITM, WHO IS SUPPLIED OF THE DIVISION OF DARTH WITH IT IS

MOTTO IS USED FOR ANY PAPPAGE OF COPED OR COMMANDE TO 10 ANY OTHER PROBLEM.

WHITTON POSMISSION PROMODER AND APPAGE AND THE APPAGE DATE 12.01.17

NOTES:
1) MATERIAL:
2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 (A) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: 0.46 lbs

8

NCR: Y	′es / No)			WORK ORDER NON-C	:OI	NFORE	MANCE / UPL	DAIL			
	•									QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	-
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update]	inern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root		Ĭ		Descri	ption of work order update		Initial	Acti	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material						İ						
Setup												
Other												
Process												
Supplier Training	\vdash											
Unapproved												
опарргочес		<u> </u>	1			<u>ι</u> Διπ	T CATE	GORY		<u> </u>	L	<u>i</u>
Landii	ng Gear			·	General							
	Bendin	g			Bend		Grain			Ovalized	Γ	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Centre Not Concentric to O/S Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/Crimped				Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		-
	Heat T	eat			Countersink		Mislabe	led		Positioned V	Vrong	-
	Inspection Strip in Tube Cut Too Short						Misread	I .		Power Loss/	Surge	Other
	Ripples in Bend Drill Holes						Offset			****		
	Torque	Waves in	Extrusio	n	Drawing	Ŀ	Out of 0	Calibration				
	Turnin	g Sequence	<u> </u>		Finish		Out of S	equence				

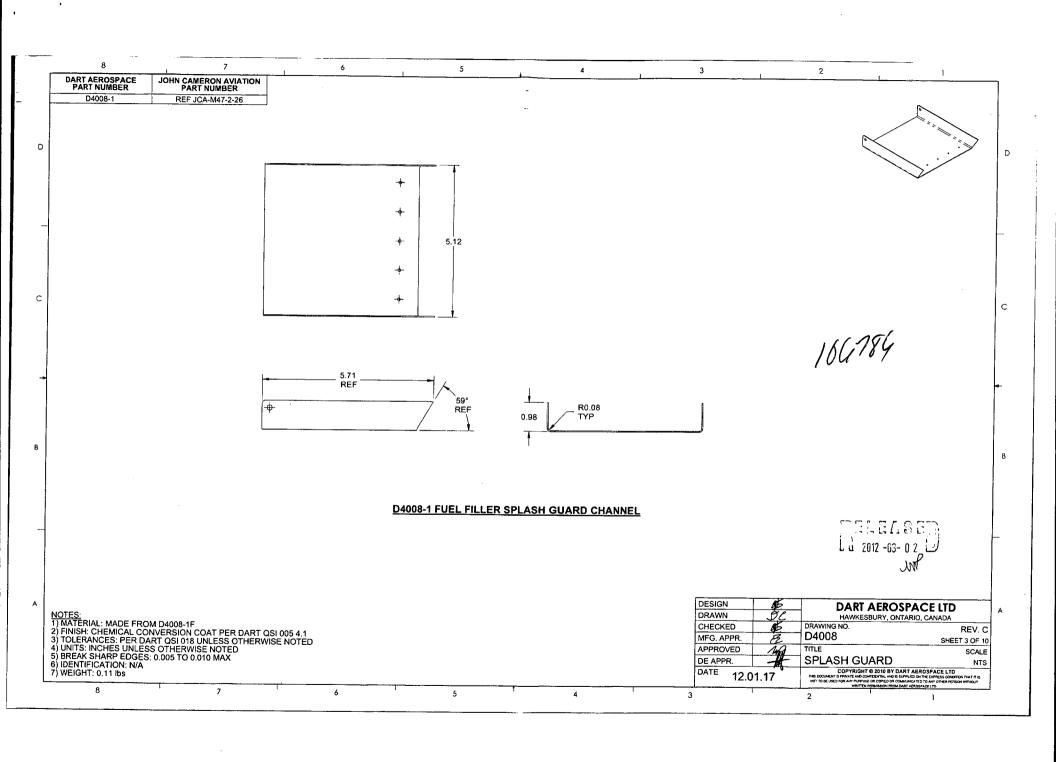
Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



												DQA:	Da	te:	
NCR:	es /	No				WORK ORDER NON-C	COI	NFORN	AANCE / UP	DATE		04.61	D-	·	
							_			-		QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
************						Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part N	lo					Scrap		ľ	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Therm	oforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	^{10.} —					Work Order Update]		Large Fab	Composite		J	Supplier		
Root					Descri	ption of work order update	-	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data														ŀ	
Equip/Tooling															
Operator															
Material															
Setup							1								
Other															
Process	Ш														
Supplier															•
Training															
Unapproved										· · · · · · · · · · · · · · · · · · ·					
			· · · · · · · · · · · · · · · · · · ·			F.	AUI	LT CATE	SORY						
Landi					_	General		-1				7	1		ī
	—	Bending Bend					_	Grain			L	Ovalized		Ш	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks Broken/Damaged						<u> </u>	4 '	on incomplete			Part Incorred			Weld
	Crushed/Crimped Burrs							-1	ons Incomplete/	Unclear	L	Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs Contamination						L	Mainte	nance			Part Moved	•		
	Heat Treat Countersink						L	Mislabe	led			Positioned V	Vrong		•
	In	spection	n Strip in	Tube		Cut Too Short	1	Misread			l	Power Loss/	Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

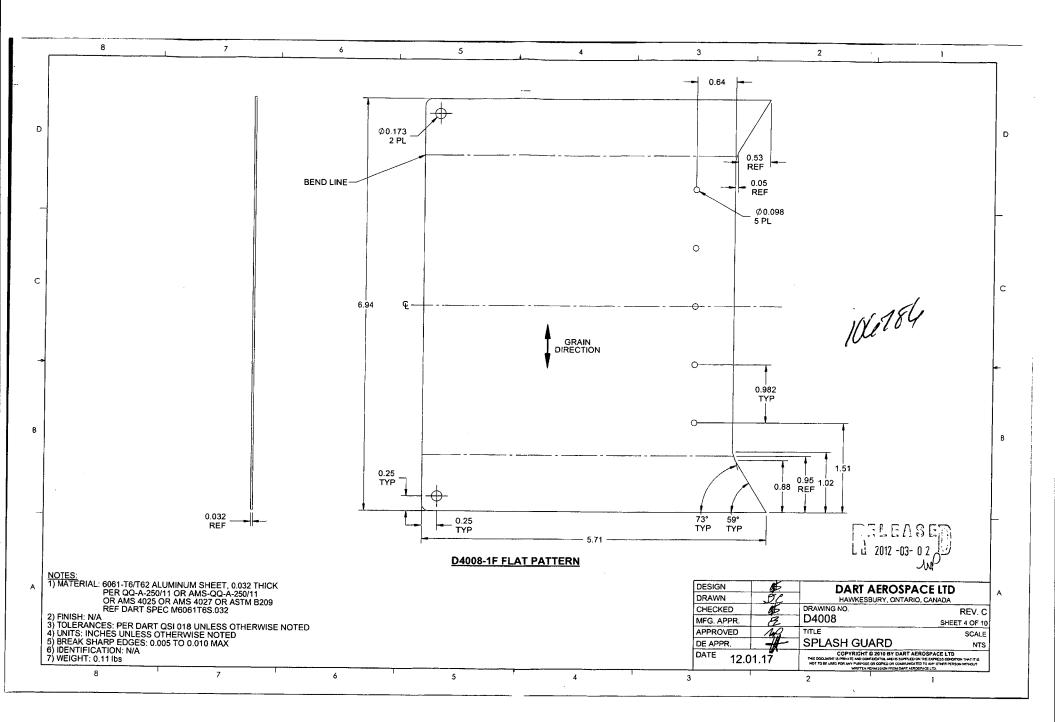
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish



										DQA:	Date	
NCR:	es /	No			WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	QA Closed:	Date	
					DISPOSITION			· ••• · · · · · · · · · · · · · · · · ·	AGAINST DE	-		
Work Orde	er:					-					,	
Part N					Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No		·		Work Order Update	_		Large Fab	Composite	_	Supplier	
Root				Descri	ption of work order update	Т	Initial	Act	ion	Sign &		
Cause	Da	te Step	Qty	(or Non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling				1		1		•				
Operator												
Material								i		İ		
Setup												
Other			1									
Process			İ			1						
Supplier												
Training	П											
Unapproved												
					F	AUI	T CATE	GORY				
Landi	ng Gear				General		_			_	·	_
	Bend	ing			Bend		Grain			Ovalized		Pressure/Forced
	Cent	re Not Cond	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	(S			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crus	ned/Crimpe	d		Burrs	Γ	Instruct	ions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuff				Contamination		Mainte	nance		Part Moved		_
	Heat	Treat			Countersink		Mislabe	led		Positioned V	Vrong	
	Insn	ection Strin	in Tuhe		Cut Too Short		Misread	1		Power Loss	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

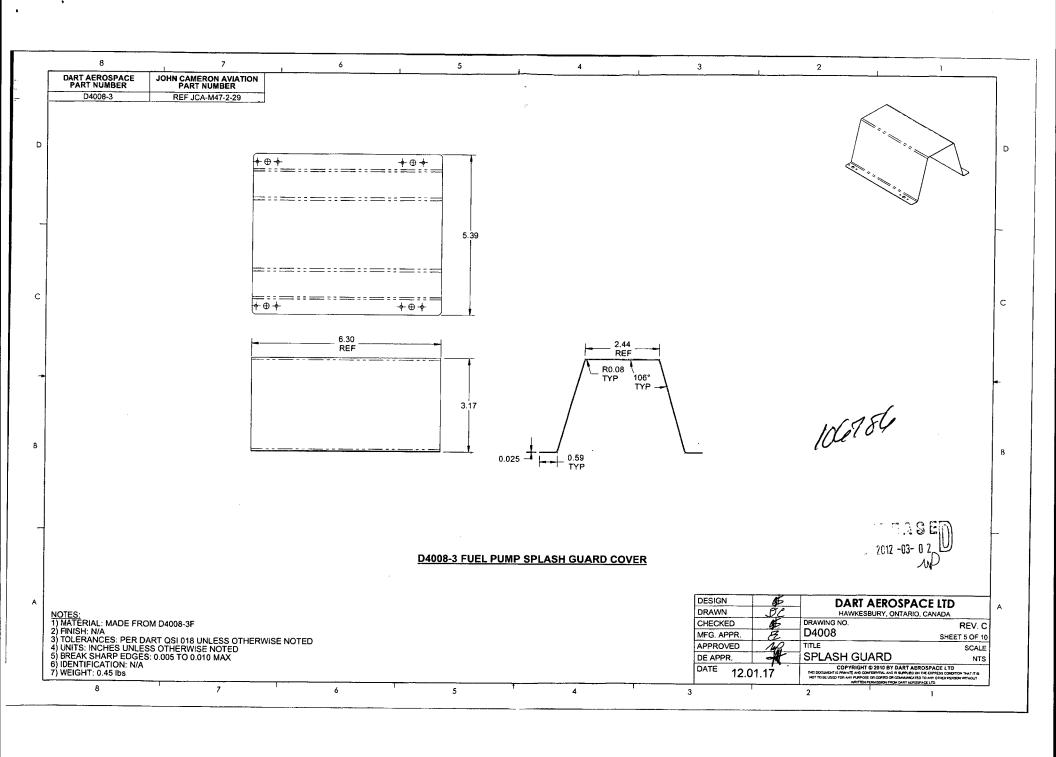
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish



NCR: Y	es / No				WORK ORDER NON-O	100	NFORM	MANCE / UP[DATE			
								<u>,</u>		QA Closed:	Date:	
Work Orde	٠ŕ:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo.				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						l						
Material												
Setup						1						
Other						Ì						
Process												
Supplier												
Training	_											
Unapproved		<u> </u>	<u> </u>	<u> </u>		<u> </u>		6657		1		
			-			AUL	T CATE	<u> </u>		***		
Landii	ng Gear Bending				General Bend	<u> </u>	Grain		Γ	Ovalized	_	Pressure/Forced
	Centre N	ot Conco	ntric to	0/5	BOM/Route	-	Hardwa	uro.		Over/Under	toloranco	Temperature/Cure
	—	or conce	iitiic to	^{0/3} -	-i	\vdash	•	ion Incomplete	<u> </u>	Part Incorre		Weld
	Cracks Broken/Damaged Crushed/Crimped Burrs				Burrs		1	ions Incomplete/L	Inclear	Part Lost/Mi		Wrong Stock Pulled
	Cuffs	Cimpea		-	Contamination	\vdash	Mainte	•		Part Moved	33116	J v v o ng Stock i anca
	Heat Tre	at			Countersink	<u> </u>	Mislabe		 	Positioned V	Vrong	
	_	n Strip in	Tube	<u> </u>	Cut Too Short	\vdash	Misread			Power Loss/		Other
	Ripples in	•		 	Drill Holes		Offset			J		1
		Vaves in I	Extrusio	n	Drawing		1	Calibration				*****
	Turning 5				Finish			Sequence				

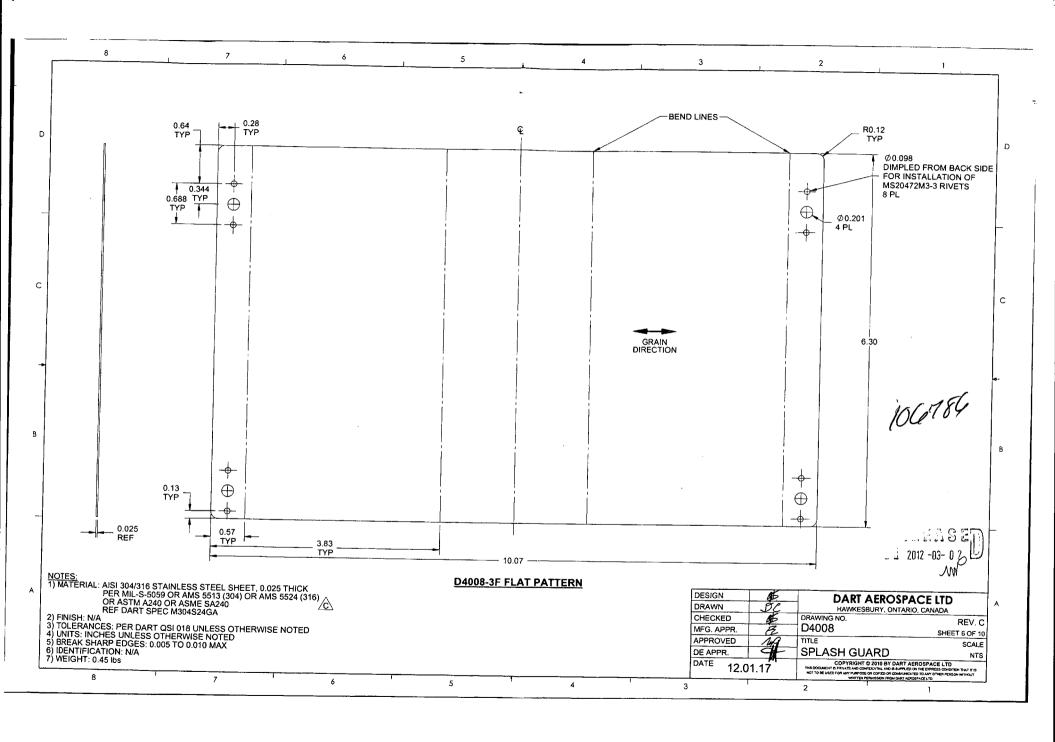
Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



										DQA:	Date:	
NCR: Y	res / No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
							T			QA Closea:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part No.					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality	
101(1					·			noforming	Finishing	4	re/Packaging	Other
NCR N	No				Work Order Update	_		Large Fab				
Root				Descri	ption of work order update	Π	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									•			
Equip/Tooling												
Operator												
Material												
Setup												
Other		ŀ										
Process												
Supplier			1									
Training												
Unapproved												
					F	AUI	LT CATE	GORY				
Landi	ng Gear				General		_					
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre 1	Not Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
:	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs		Instructi	ions Incomplete/	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		-
	Heat Tro	eat			Countersink		Mislabe	led		Positioned V	Vrong	
	inspecti	on Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

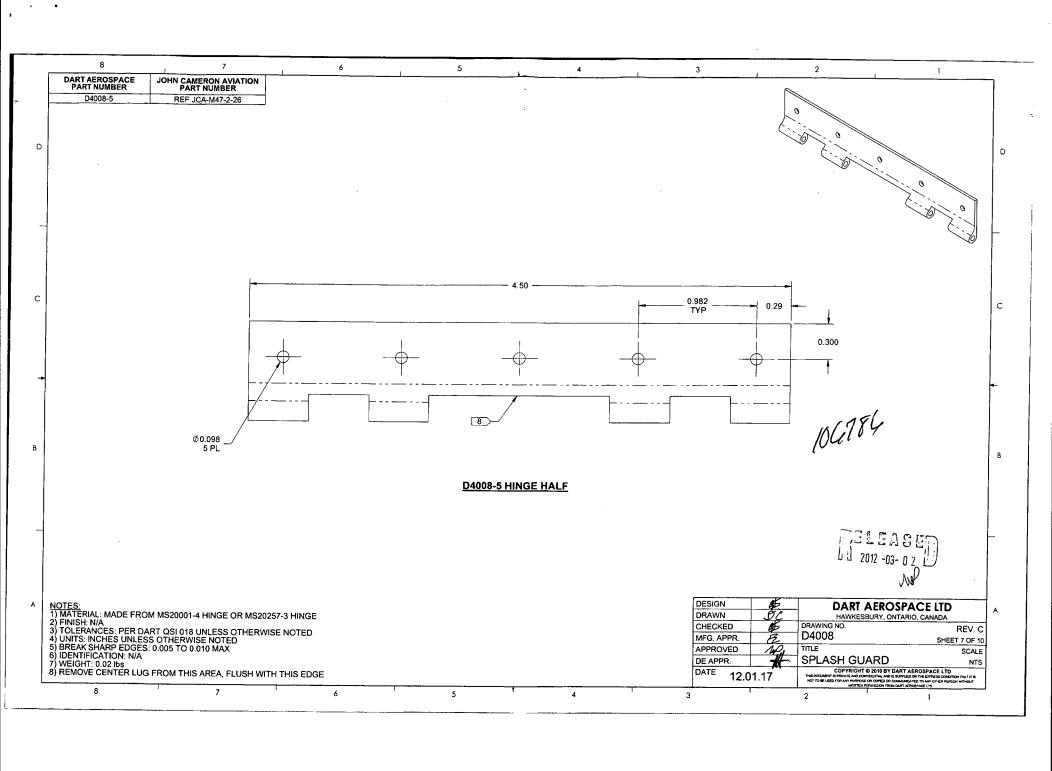
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



						-				DQA	: Da	te:	
NCR: Y	'es / No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE			•	
										QA Closed	l: Da	te:	
Work Orde	a ri •				DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
WOIK OIG	···				Rework		Skid-tube	Crosstube	1	Water Jet	П	Engineering	
Part N	lo.				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.		Quality
					— — I			noforming	Finishing	Rec/St	ore/Packaging	П	Other
NCR N	lo				Work Order Update]		Large Fab	Composite				
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &			· · · · · · · · · · · · · · · · · · ·
Cause	Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material						Ì							
Setup													
Other													
Process		Ì											
Supplier													
Training													
Unapproved		<u> </u>			,								
					· · · · · · · · · · · · · · · · · · ·	AUI	T CATE	GORY					
Landi	ng Gear				General	_	7			7			
	Bending			<u> </u>	Bend		Grain			Ovalized			Pressure/Forced
	Centre N	ot Conce	ntric to	o/s _	BOM/Route	<u> </u>	Hardwa		<u></u>	Over/Unde		-	Temperature/Cure
	Cracks				Broken/Damaged	_	4 '	on incomplete		Part Incorr		-	Weld
	Crushed/	'Crimped		_	Burrs		4	ions Incomplete/	'Unclear	Part Lost/N	•	<u></u>	Wrong Stock Pulled
	Cuffs				Contamination		Mainte		<u> </u>	Part Move			
	Heat Tre	at			Countersink		Mislabe	led		Positioned	-		
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss	/Surge	Ш	Other
	Rinnles i	n Rend			Drill Holes	1	Offcot						

Out of Calibration

Outside Dimensions

Out of Sequence

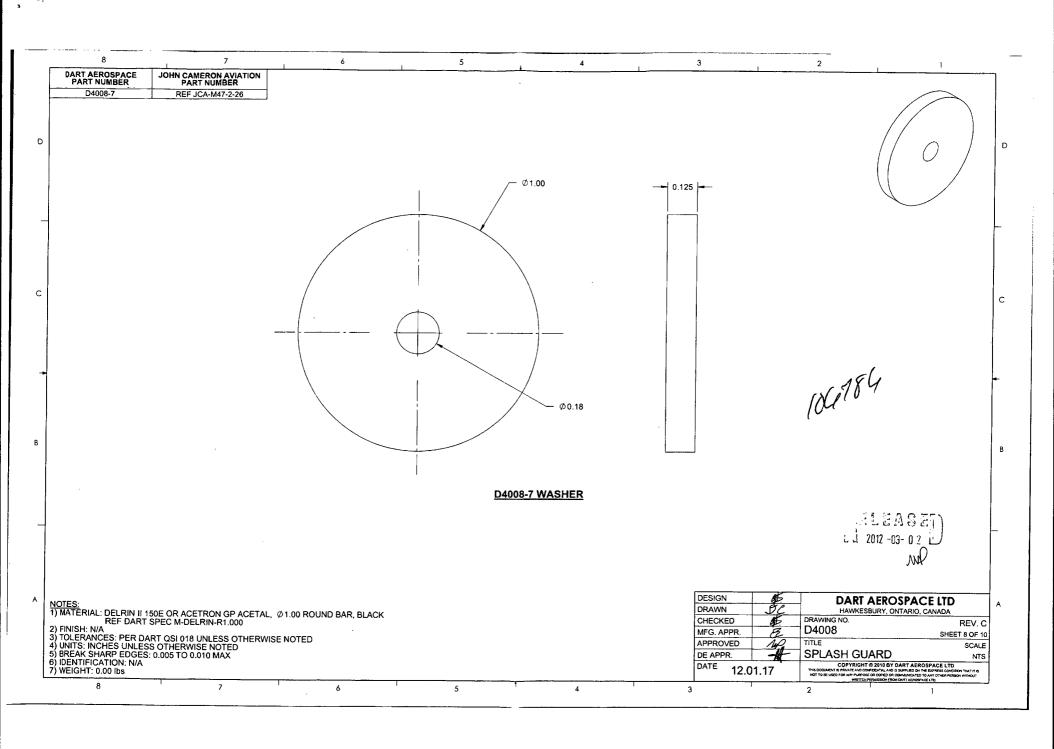
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			OA Closed:	Date:	

	QA Closed: Date:													
Work Orde	er:					DISPOSITION		AGAINS			T DEPARTMENT/PROCESS			
		. "				Rework	1	Skid-tube Crosstub				Water Jet		Engineering
Part N	No.					Scrap	1	Machining	Small Fab	П	Pro	d. Eng. Coor.	П	Quality
	_					Use-as-is	1 Th	ermoforming	Finishing		Rec/Stor	re/Packaging	П	Other
NCR N	No.					Work Order Update	1 	Large Fab	Composite			Supplier	_	
						<u> </u>								
Root					Descri	ption of work order update	Initia	1	Action	S	ign &			
Cause		Date	Step	Qty	(or Non-conformance	Chief E	ng I	Description		Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling														
Operator													l	
Material														
Setup														
Other				i										
Process														
Supplier										İ				
Training														
Unapproved														
				·		F	AULT CA	TEGORY						
Landi	ng Ge	ear				General		-						
	∐E	Bending				Bend	Gra	in		Ova	alized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	Hard	dware		Ove	er/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	Insp	ection Incomple	te	Par	t Incorrec	ct	ال	Weld
		Crushed/0	Crimped			Burrs	Inst	uctions Incomp	lete/Unclear	Par	t Lost/Mi	ssing	\ ا	Wrong Stock Pulled
		Cuffs				Contamination	Mai	ntenance		Par	t Moved			
		Heat Treat				Countersink	Misl	abeled		Pos	itioned V	Vrong		
	∐ı	nspection	n Strip in	Tube		Cut Too Short	Misi	ead		Pov	ver Loss/:	Surge		Other
		Ripples in	Bend			Drill Holes	Offs	et						
	\Box	Torque W	aves in E	xtrusio	n $lacksquare$	Drawing	Out	of Calibration						
		Turning S	equence			Finish	Out	of Sequence						
	\Box	Maya/Tw	ist in Tuk	10		Teolio		Outside Dimensions						

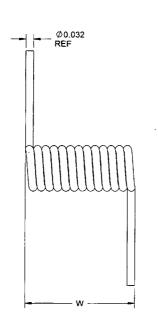
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

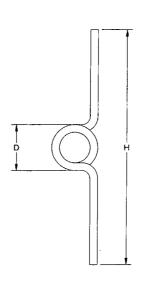
DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4008-9 REF JCA-M47-2-26

D

SPECIFICATION CONTROL DRAWING







DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

DESIGN	5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
DRAWN	DC							
CHECKED	\$	DRAWING NO.	REV. C					
MFG. APPR.	E	D4008	SHEET 9 OF 10					
APPROVED	10	TITLE	SCALE					
DE APPR.	-#-	SPLASH GUARD	NTS					
DATE 12.0	1.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS HISWATE AND OCCUPANTIAL WHO IS SUPPLIED ON THE COPIESS CONDITION THAT IT IS NOT TO BE USED FOR ANY ENTITIES PROMISSION OF BEING AND ALL OF ALL OF A THE TOTAL OF THE COPY OF THE						

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	COI	NFORM	MANCE / UPD	ATE	OA Classide	Dete	
	-						r			QA Closed:	Date:	·
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part No.					Rework Scrap Use-as-is	Skid-tube Crosstube Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	lo	*			Work Order Update	_		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	П	Initial	Actio	on	Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Cr	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						ł						
Operator												
Material						1						
Setup									•			
Other												
Process				ļ								
Supplier												
Training		1.										
Unapproved												
					F	ΑUL	T CATE	GORY		-		
Landir	ng Gear				General		_					_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
[Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	t 🗌	Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		-
	Heat Tre	at			Countersink		Mislabe	led		Positioned V	/rong	_
	Inspection	on Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset					

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

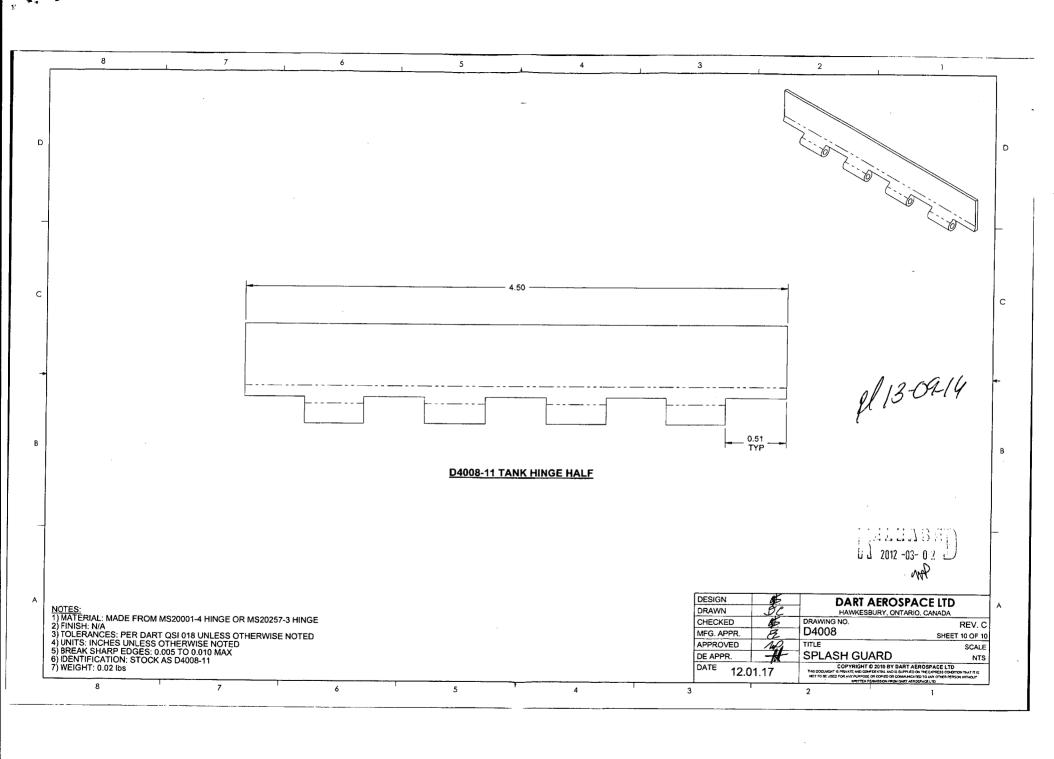
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



									DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-O	CONFC	PRMANCE / UF	PDATE	QA Closed:	Date:	
				. <u> </u>	DISPOSITION		.,	AGAINST DI			
Part No.					Rework Scrap Use-as-is	Skid-tube Crosstube Scrap Machining Small Fab e-as-is Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	0				Work Order Update	J	Large Fab	Composite	<u> </u>	Supplier	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initia Chief E		ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
onapproved		1	l		F	AULT CA	ATEGORY	 	<u> </u>	<u> </u>	1
Landin		,			General						1
- - - - - - - - -	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		in dware dection Incomplete ructions Incomplete intenance labeled read set of Calibration of Sequence	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Wave/Tw	ist in Tul	oe .		Folio	Out	side Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G